



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D350-636-022**  
**Job Sheet 192965**



**Part No:** D350-636-022

**Job Qty:** 1 ea

**Part Name:** AS350/355 - Skid tubes - Standard w/ Standard Wearplates - RH



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 4/5/19

**Job Tracking No:**

**Due Date:** 4/30/19

**Created By:** Marie Lajeunesse

**Type:** Stock

**Description:** SIOP

**Note:** D2750-052 REV.H, IIN-D350-636 REV.K IPP REV.A 18.11.27 NEW ISSUE DD VERF:JFS

**Ship Via:**

**Bill of Materials**

5172081 RH





Container No: S172081



Part: D350-636-022

Job No: 192965

Serial No/Batch: S172081

Revision: H/K

Inspector:

Exp Date:

Instructions: FAA STC SR00646SE 18/10/17, TC STC SH99-7 Issue 2, EASA STC

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL: 1 813 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com



| Job Routing |                    |       |            |          |           |         |                       |           |                 |
|-------------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-----------------|
| Op No       | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off        |
|             |                    |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                 |
| 90          | Start up Operation | 1 Ea  | 4/30/19    | 4/30/19  | 0.00      | 0.00    | Start Up Skidtubes-1  |           | BE              |
| 110         | Skidtubes          | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 4.36    | Skidtubes-4           |           | BE              |
| 120         | QC                 | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 0.00    | QC10                  |           | CPC DAS         |
| 130         | QC                 | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 0.00    | QC5                   |           | MAY 01 2019 68  |
| 140         | HandFinish         | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 0.91    | HandFinish1           |           | D.R. 19/04/2019 |
| 150         | QC                 | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 0.00    | QC7-2                 |           | BE              |
| 160         | Skidtubes          | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 4.36    | Skidtubes-1           |           | BE DO           |
| 170         | QC                 | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 0.00    | QC10                  |           | CPC             |
| 180         | QC                 | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 0.00    | QC5                   |           | CPC             |
| 190         | HandFinish         | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 0.91    | HandFinish2           |           | AS 19-6-2       |
| 200         | SprayPaint         | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 0.69    | Spray Paint           |           | AS 19-6-2       |
| 205         | Outsource          | 1 pcs | 4/30/19    | 4/30/19  |           |         | ATE003-VC             | 5         | NR              |
| 210         | QC                 | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 0.00    | QC14                  |           | M 14-6-3        |
| 230         | HandFinish         | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 0.91    | HandFinish4           |           | M 14-6-13       |
| 240         | QC                 | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 0.00    | QC5                   |           |                 |
| 250         | Packaging          | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 0.00    | Packaging1-3          |           |                 |
| 260         | QC                 | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 0.00    | QC4                   | DAS       | MB 06/20/2019   |
| 270         | Packaging          | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 0.00    | Packaging3-1          | 58        | MB 06/20/2019   |
| 275         | DC                 | 1 pcs | 4/30/19    | 4/30/19  | 0.00      | 0.00    | DC                    | 21        | JUN 20 2019     |
| 280         | QC21-FG            | 1 Ea  | 4/30/19    | 4/30/19  | 0.00      | 0.00    | QC21                  | 21        | JUN 20 2019     |

Part Op 110 - 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 (D2750-6 details). Drill using drill Jig DT8150. 4- Locate Descriptions: DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail BM to 0.297" (total of 2 holes per side) and one 0.201" each side as per dwg 8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 9- Grind welds flush as per Dwg D2750

160 - 1- Open up holes of Detail BN using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 4- Chamfer holes of Detail BN, ground handling and float holes per dwg D2750 (welding instructions on sheet 16) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5163437 exp. date: 12-07-2019 ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)\*\*\* 8- Weld spacers D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: 138989 10-Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint.

180 - \*\*\*VERIFY C'BOARD IS GOOD\*\*\*

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5179552 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5184740

210 - Inspect for foreign object per QSI 024

230 - 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-4, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 5174342 EXP DATE: 14-12-2 5- Coat all exposed fasteners with "LPS Procyon" batch: 14133690

270 - Package as per PPP D350-636-012

275 - record fwd angle: 89.8 Photocopy blue file and type labels per PPP D350-636-012 CHG 008

F6072



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## Job BOM

010139

| Part / Item     | Component Name     | Quantity      | Operation             | Container |
|-----------------|--------------------|---------------|-----------------------|-----------|
| D2600-3-BENT-RH | Extrusion Bent RH  | 1 pcs (1 ea)  | 90-Start up Operation | 5166246   |
| D2744           | Cap                | 1 pcs (1 ea)  | 110-Skidtubes         | 5150291   |
| D2739           | 350 I-Beam         | 1 pcs (1 ea)  | 160-Skidtubes         | 5153407   |
| D2743           | Crossbolt Spacer   | 8 pcs (8 ea)  | 160-Skidtubes         | 5162846   |
| AN3C5A          | Bolt 5174233 (x34) | 34 Ea (34 ea) | 230-HandFinish        | 5176452   |
| AN3C6A          | Bolt               | 4 Ea (4 ea)   | 230-HandFinish        | 5174232   |
| AN6C44A         | Bolt               | 4 Ea (4 ea)   | 230-HandFinish        | 5176396   |
| AN8C35A         | Bolt               | 1 Ea (1 ea)   | 230-HandFinish        | 5167090   |
| D2745           | Bushing            | 8 pcs (8 ea)  | 230-HandFinish        | * 5188182 |
| D3488-4         | Blade Fitting, RH  | 1 pcs (1 ea)  | 230-HandFinish        | 5179461   |
| D3537-1         | Wearpad            | 3 pcs (3 ea)  | 230-HandFinish        | 5181203   |
| D3631-1         | Washer             | 8 pcs (8 ea)  | 230-HandFinish        | 5181112   |
| D3791-1         | Wearpad            | 1 Ea (1 ea)   | 230-HandFinish        | 5180586   |
| D3793-1         | Wearplate Fwd      | 1 pcs (1 ea)  | 230-HandFinish        | 5176769   |
| D3793-3         | Wearplate Aft      | 1 pcs (1 ea)  | 230-HandFinish        | * 5187587 |
| MS21043-6       | Nut                | 4 Ea (4 ea)   | 230-HandFinish        | 5181777   |
| MS21083C8       | Nut                | 1 Ea (1 ea)   | 230-HandFinish        | 5167203-1 |
| NAS1149C0332R   | Washer             | 38 Ea (38 ea) | 230-HandFinish        | 5158072   |
| NAS1149C0832R   | Washer             | 1 Ea (1 ea)   | 230-HandFinish        | 5076017-2 |
| NAS1515H3L      | Washer             | 4 Ea (4 ea)   | 230-HandFinish        | 5083559   |
| ALS4-1032-225   | Rivnut             | 38 Ea (38 ea) | 230-HandFinish        | 5167517   |
| AN3C34A         | Bolt               | 1 Ea (1 ea)   | 230-HandFinish        | 5186041-1 |
| D3793-5         | Wearpad            | 1 pcs (1 ea)  | 230-HandFinish        | * 5189162 |
| MS21043-3       | Nut                | 1 Ea (1 ea)   | 230-HandFinish        | 5092560   |
| NAS1149C0363R   | Washer             | 2 Ea (2 ea)   | 230-HandFinish        | 5135100   |
| AN8C21A         | Bolt               | 2 Ea (2 ea)   | 250-Packaging         | 5160987   |
| D2741           | Replacement Blade  | 1 pcs (1 ea)  | 250-Packaging         | 5159549   |
| MS21083C8       | Nut                | 2 Ea (2 ea)   | 250-Packaging         | 5167203   |
| NAS1149D0863J   | Washer             | 2 Ea (2 ea)   | 250-Packaging         | 5167718   |

## Job Allocations

| Operation             | Component Part  | Required | Inventory | Allocated |
|-----------------------|-----------------|----------|-----------|-----------|
| 90-Start up Operation | D2600-3-BENT-RH | 1        | 10        | 0         |
| 110-Skidtubes         | D2744           | 1        | 31        | 0         |
| 160-Skidtubes         | D2739           | 1        | 11        | 0         |
|                       | D2743           | 8        | 159       | 0         |
| 230-HandFinish        | ALS4-1032-225   | 38       | 1,361     | 0         |
|                       | AN3C34A         | 1        | 12        | 0         |
|                       | AN3C5A          | 34       | 1,382     | 0         |
|                       | AN3C6A          | 4        | 226       | 0         |
|                       | AN6C44A         | 4        | 140       | 0         |
|                       | AN8C35A         | 1        | 64        | 0         |
|                       | D2745           | 8        | 184       | 0         |
|                       | D3488-4         | 1        | 4         | 0         |
|                       | D3537-1         | 3        | 18        | 0         |
|                       | D3631-1         | 8        | 229       | 0         |
|                       | D3791-1         | 1        | 5         | 0         |
|                       | D3793-1         | 1        | 9         | 0         |
|                       | D3793-3         | 1        | 6         | 0         |
|                       | D3793-5         | 1        | 17        | 0         |
|                       | MS21043-3       | 1        | 1,146     | 0         |
|                       | MS21043-6       | 4        | 168       | 0         |
|                       | MS21083C8       | 1        | 340       | 0         |
|                       | NAS1149C0332R   | 38       | 4,345     | 0         |
|                       | NAS1149C0363R   | 2        | 495       | 0         |
|                       | NAS1149C0832R   | 1        | 342       | 0         |
|                       | NAS1515H3L      | 4        | 366       | 0         |
| 250-Packaging         | AN8C21A         | 2        | 91        | 0         |
|                       | D2741           | 1        | 67        | 0         |
|                       | MS21083C8       | 2        | 340       | 0         |
|                       | NAS1149D0863J   | 2        | 591       | 0         |



**Part Specifications**

Specifications could not be found.

*Plex 4/5/19 7:20 AM Dart.lajeunesse.marie*



| QTY<br>-041 | QTY<br>-042 | QTY<br>-043 | QTY<br>-044 | QTY<br>-051 | QTY<br>-052 | P/N           | DESCRIPTION               |
|-------------|-------------|-------------|-------------|-------------|-------------|---------------|---------------------------|
| X           |             |             |             |             |             | D2750-041     | 350 SKIDTUBE ASSEMBLY, LH |
|             | X           |             |             |             |             | D2750-042     | 350 SKIDTUBE ASSEMBLY, RH |
|             |             | X           |             |             |             | D2750-043     | 350 SKIDTUBE ASSEMBLY, LH |
|             |             |             | X           |             |             | D2750-044     | 350 SKIDTUBE ASSEMBLY, RH |
|             |             |             |             | X           |             | D2750-051     | 350 SKIDTUBE ASSEMBLY, LH |
|             |             |             |             |             | X           | D2750-052     | 350 SKIDTUBE ASSEMBLY, RH |
| 1           | 1           | 1           | 1           | 1           | 1           | D2739         | WEB                       |
| 8           | 8           | 8           | 8           | 8           | 8           | D2743         | CROSS BOLT SPACER         |
| 1           | 1           | 1           | 1           | 1           | 1           | D2744         | CAP                       |
| 8           | 8           | 8           | 8           | 8           | 8           | D2745         | BUSHING                   |
| 1           |             |             |             |             |             | D2750-1       | 350 SKIDTUBE ASSEMBLY     |
|             | 1           |             |             |             |             | D2750-2       | 350 SKIDTUBE ASSEMBLY     |
|             |             | 1           |             |             |             | D2750-3       | 350 SKIDTUBE ASSEMBLY     |
|             |             |             | 1           |             |             | D2750-4       | 350 SKIDTUBE ASSEMBLY     |
|             |             |             |             | 1           |             | D2750-5       | 350 SKIDTUBE ASSEMBLY     |
|             |             |             |             |             | 1           | D2750-6       | 350 SKIDTUBE ASSEMBLY     |
| 1           |             | 1           |             | 1           |             | D3488-3       | BLADE FITTING, LH         |
|             | 1           |             | 1           |             | 1           | D3488-4       | BLADE FITTING, RH         |
| 4           | 4           | 4           | 4           |             |             | D3490-1       | CROSS BOLT SPACER         |
| 4           | 4           |             |             |             |             | D3490-3       | CROSS BOLT SPACER         |
|             |             | 4           | 4           |             |             | D3490-5       | CROSS BOLT SPACER         |
| 8           | 8           | 8           | 8           |             |             | D3492-041     | PLUG                      |
| 8           | 8           |             |             |             |             | D3492-043     | PLUG                      |
|             |             | 8           | 8           |             |             | D3492-045     | PLUG                      |
| 3           | 3           | 3           | 3           | 3           | 3           | D3537-1       | WEARPAD                   |
| 8           | 8           | 8           | 8           | 8           | 8           | D3631-1       | WASHER                    |
| 1           | 1           | 1           | 1           | 1           | 1           | D3791-1       | WEARPLATE                 |
| 1           | 1           | 1           | 1           | 1           | 1           | D3793-1       | WEARSHOE                  |
| 1           | 1           | 1           | 1           | 1           | 1           | D3793-3       | WEARSHOE                  |
| 1           | 1           | 1           | 1           | 1           | 1           | D3793-5       | WEARSHOE                  |
| 38          | 38          | 38          | 38          | 38          | 38          | ALS4-1032-225 | INSERT                    |
|             |             |             |             | 1           | 1           | AN3C34A       | BOLT                      |
| 34          | 34          | 34          | 34          | 34          | 34          | AN3C5A        | BOLT                      |
| 4           | 4           | 4           | 4           | 4           | 4           | AN3C6A        | BOLT                      |
| 4           | 4           | 4           | 4           | 4           | 4           | AN6C44A       | BOLT                      |
| 1           | 1           | 1           | 1           | 1           | 1           | AN8C35A       | BOLT                      |
|             |             |             |             | 1           | 1           | MS21043-3     | NUT                       |
| 4           | 4           | 4           | 4           | 4           | 4           | MS21043-6     | NUT                       |
| 1           | 1           | 1           | 1           | 1           | 1           | MS21083C8     | NUT                       |
| 38          | 38          | 38          | 38          | 38          | 38          | NAS1149C0332R | WASHER                    |
|             |             |             |             | 2           | 2           | NAS1149C0363R | WASHER                    |
| 1           | 1           | 1           | 1           | 1           | 1           | NAS1149C0832R | WASHER                    |
| 4           | 4           | 4           | 4           | 4           | 4           | NAS1515H3L    | WASHER                    |

# NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.1 lbs  
D2750-051/-052 = 25.7 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 19/64" SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

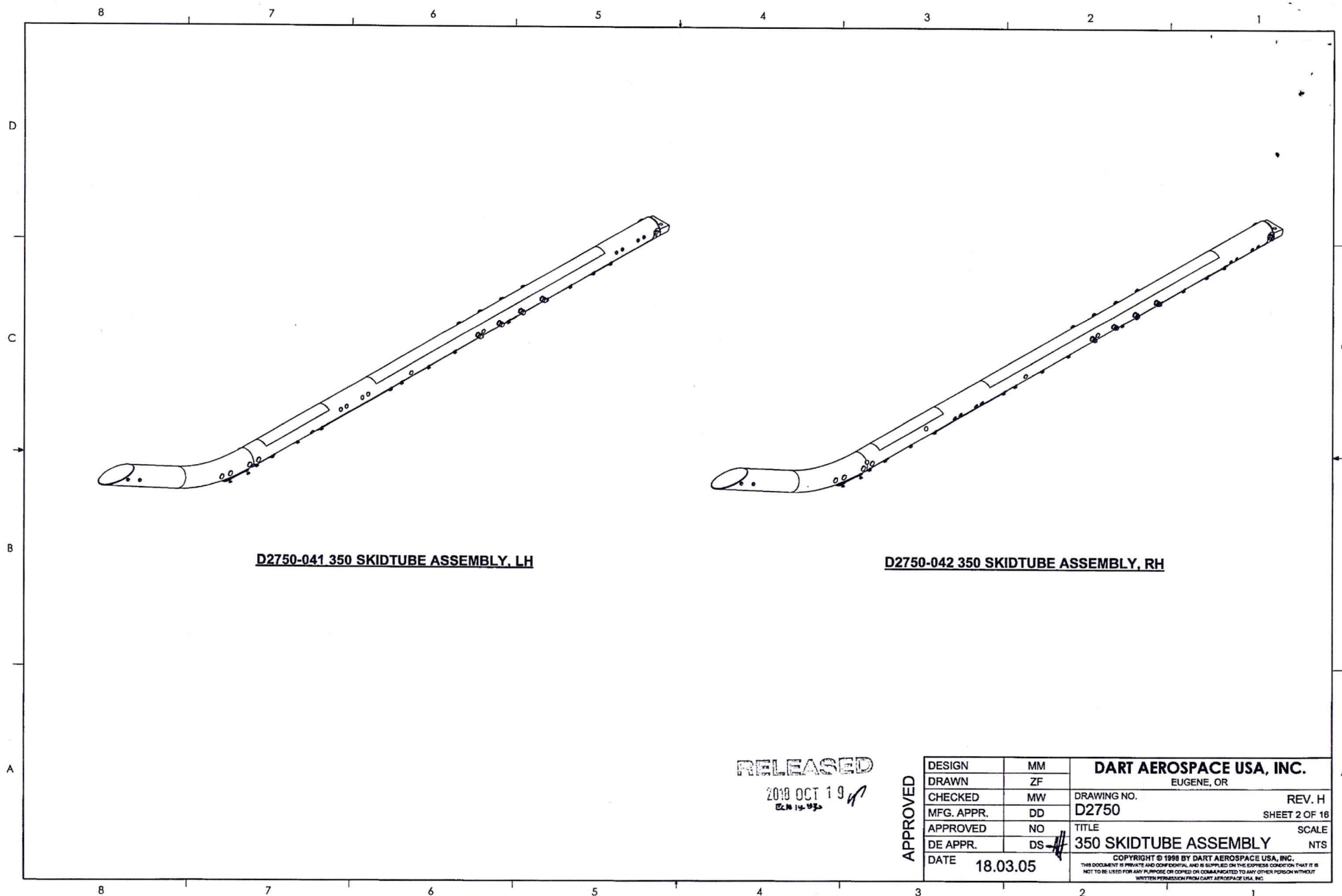
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|            |                                                                                                                                                                                                                                                                                                                                                                                                        |                                              |               |
|------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------|---------------|
| H          | ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-16); ADDED D2750-5/-6 (ZN C5-1 SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-11/-12/-13/-14); D3793-5 REPLACES D3535-25 (ZN B8-1, C4-11/-12/-13/-14); NAS1149C0332R REPLACES AN80C10L (ZN A5-1, B1-11/-12/-13/-14, C7-11/-12/-13/-14); NAS1149C0832R REPLACES AN960C816L (ZN A5-1, C1-11/-12/-13/-14); REMOVED D3794-1/-3, AND D3536-25 GASKETS | ZF                                           | 18.03.05      |
| G          | CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS +0.01/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757                                                                                                                                 | MB                                           | 13.07.11      |
| F          | INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043                   | PH                                           | 08.07.16      |
| E          | CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8                                                                                                                                                                                               | CB                                           | 07.05.17      |
| D          | ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157                                                                                                                                                                                                                                                                                                                                     | PH                                           | 06.01.05      |
| C          | ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740                                                                                                                                                                                                                                                                                                                                                       | CP                                           | 98.11.18      |
| B          | CHANGE MS24694-S293 TO AN8-16A                                                                                                                                                                                                                                                                                                                                                                         | CP                                           | 98.09.01      |
| A          | NEW ISSUE                                                                                                                                                                                                                                                                                                                                                                                              | DS                                           | 98.04.16      |
| REV.       | DESCRIPTION                                                                                                                                                                                                                                                                                                                                                                                            | BY                                           | DATE          |
| DESIGN     | MM                                                                                                                                                                                                                                                                                                                                                                                                     | DART AEROSPACE USA, INC.                     |               |
| DRAWN      | ZF                                                                                                                                                                                                                                                                                                                                                                                                     | EUGENE, OR                                   |               |
| CHECKED    | MW                                                                                                                                                                                                                                                                                                                                                                                                     | DRAWING NO.                                  | REV. H        |
| MFG. APPR. | DD                                                                                                                                                                                                                                                                                                                                                                                                     | D2750                                        | SHEET 1 OF 16 |
| APPROVED   | NO                                                                                                                                                                                                                                                                                                                                                                                                     | TITLE                                        | SCALE         |
| DE APPR.   | DS                                                                                                                                                                                                                                                                                                                                                                                                     | 350 SKIDTUBE ASSEMBLY                        | NTS           |
| DATE       | 18.03.05                                                                                                                                                                                                                                                                                                                                                                                               | COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. |               |

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D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

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APPROVED

|            |          |                                                                                                                                                                                                                                                                                                              |        |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|
| DESIGN     | MM       | <b>DART AEROSPACE USA, INC.</b><br>EUGENE, OR                                                                                                                                                                                                                                                                |        |
| DRAWN      | ZF       |                                                                                                                                                                                                                                                                                                              |        |
| CHECKED    | MW       | DRAWING NO.<br><b>D2750</b>                                                                                                                                                                                                                                                                                  | REV. H |
| MFG. APPR. | DD       | SHEET 2 OF 18                                                                                                                                                                                                                                                                                                |        |
| APPROVED   | NO       | TITLE                                                                                                                                                                                                                                                                                                        | SCALE  |
| DE APPR.   | DS       | <b>350 SKIDTUBE ASSEMBLY</b>                                                                                                                                                                                                                                                                                 | NTS    |
| DATE       | 18.03.05 | <small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br/>WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> |        |



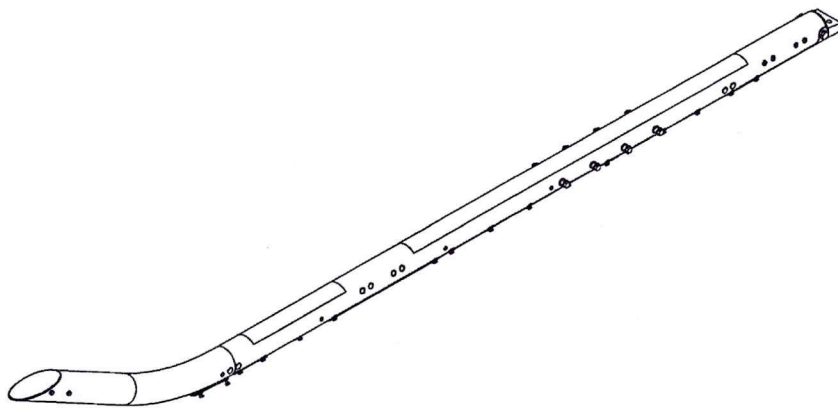
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D

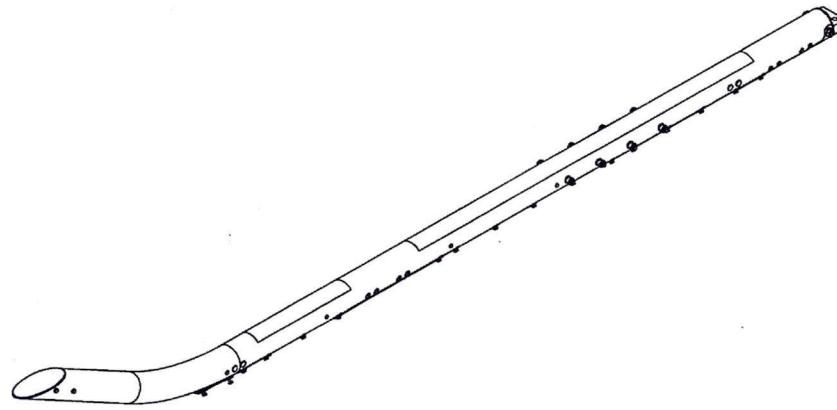
C

B

A



**D2750-043 350 SKIDTUBE ASSEMBLY, LH**



**D2750-044 350 SKIDTUBE ASSEMBLY, RH**

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|            |          |                                                                                                                                                                                                                                                                                           |        |
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| DESIGN     | MM       | DART AEROSPACE USA, INC.                                                                                                                                                                                                                                                                  |        |
| DRAWN      | ZF       | EUGENE, OR                                                                                                                                                                                                                                                                                |        |
| CHECKED    | MW       | DRAWING NO. D2750                                                                                                                                                                                                                                                                         | REV. H |
| MFG. APPR. | DD       | SHEET 3 OF 16                                                                                                                                                                                                                                                                             |        |
| APPROVED   | NO       | TITLE                                                                                                                                                                                                                                                                                     | SCALE  |
| DE APPR.   | DS       | 350 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                                     | NTS    |
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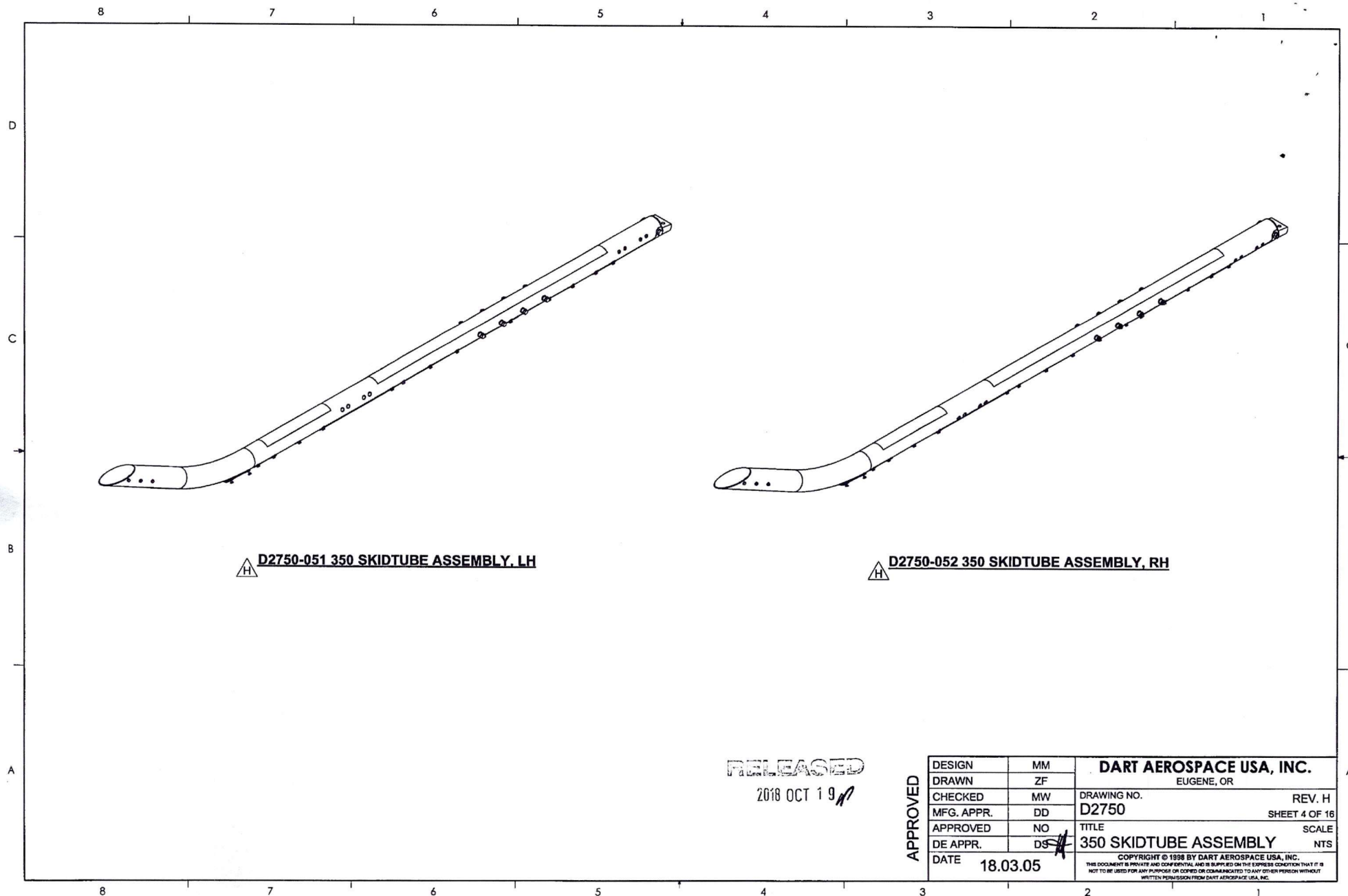
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**D2750-051 350 SKIDTUBE ASSEMBLY, LH**

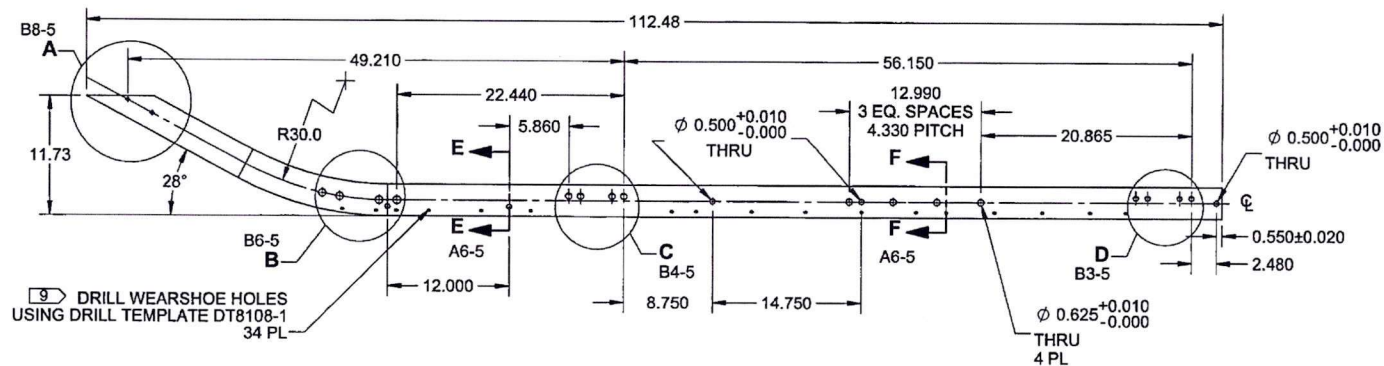
**D2750-052 350 SKIDTUBE ASSEMBLY, RH**

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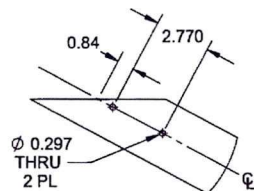
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| DESIGN     | MM       | <b>DART AEROSPACE USA, INC.</b>                                                                                                                                                                                                                                                                     |               |
| DRAWN      | ZF       | EUGENE, OR                                                                                                                                                                                                                                                                                          |               |
| CHECKED    | MW       | DRAWING NO.                                                                                                                                                                                                                                                                                         | REV. H        |
| MFG. APPR. | DD       | <b>D2750</b>                                                                                                                                                                                                                                                                                        | SHEET 4 OF 16 |
| APPROVED   | NO       | TITLE                                                                                                                                                                                                                                                                                               | SCALE         |
| DE APPR.   | DS       | <b>350 SKIDTUBE ASSEMBLY</b>                                                                                                                                                                                                                                                                        | NTS           |
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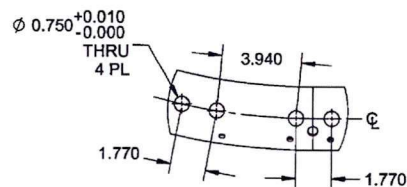




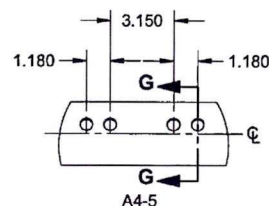
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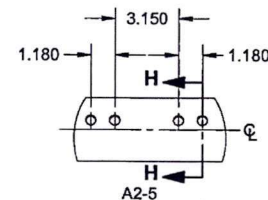
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SCALE 2X



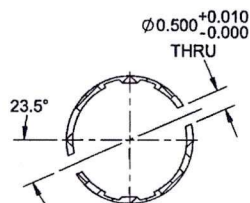
**DETAIL B**  
SCALE 2X



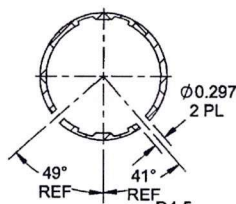
**DETAIL C**  
SCALE 2X



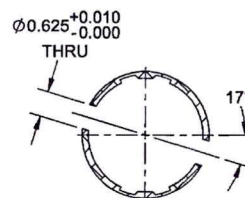
**DETAIL D**  
SCALE 2X



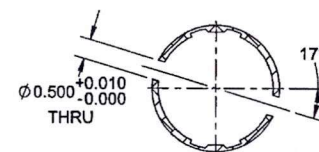
**SECTION E-E**  
SCALE 4X, 2 PL



**SECTION F-F**  
SCALE 4X, 17 PL



**SECTION G-G**  
SCALE 4X, 4 PL



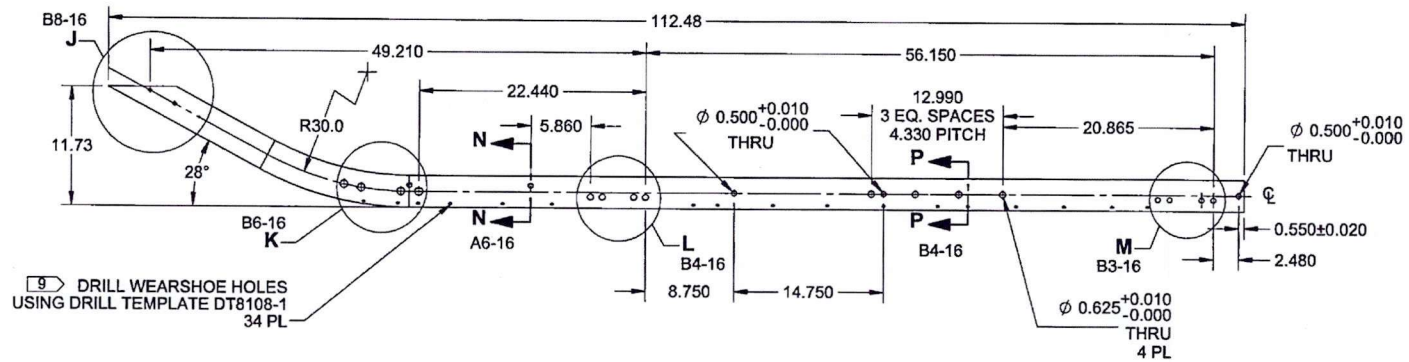
**SECTION H-H**  
SCALE 4X, 4 PL

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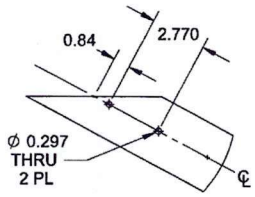
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|------------|----------|---------------------------------|---------------|
| DESIGN     | MM       | <b>DART AEROSPACE USA, INC.</b> |               |
| DRAWN      | ZF       | EUGENE, OR                      |               |
| CHECKED    | MW       | DRAWING NO. <b>D2750</b>        | REV. H        |
| MFG. APPR. | DD       | TITLE                           | SHEET 5 OF 16 |
| APPROVED   | NO       | SCALE                           |               |
| DE APPR.   | DS       | <b>350 SKIDTUBE ASSEMBLY</b>    |               |
| DATE       | 18.03.05 | NTS                             |               |

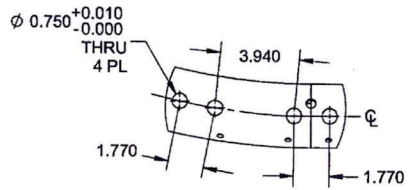
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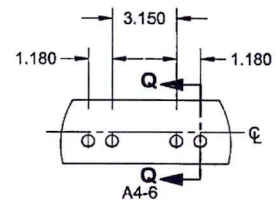
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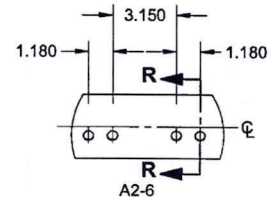
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SCALE 2X



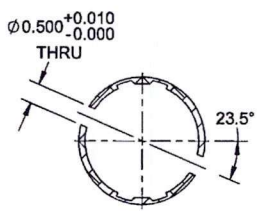
**DETAIL K**  
SCALE 2X



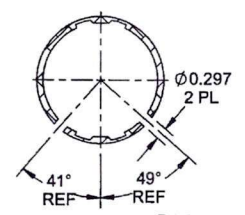
**DETAIL L**  
SCALE 2X



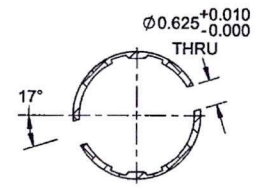
**DETAIL M**  
SCALE 2X



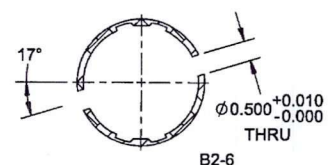
**SECTION N-N**  
SCALE 4X, 2 PL



**SECTION P-P**  
SCALE 4X, 17 PL



**SECTION Q-Q**  
SCALE 4X, 4 PL

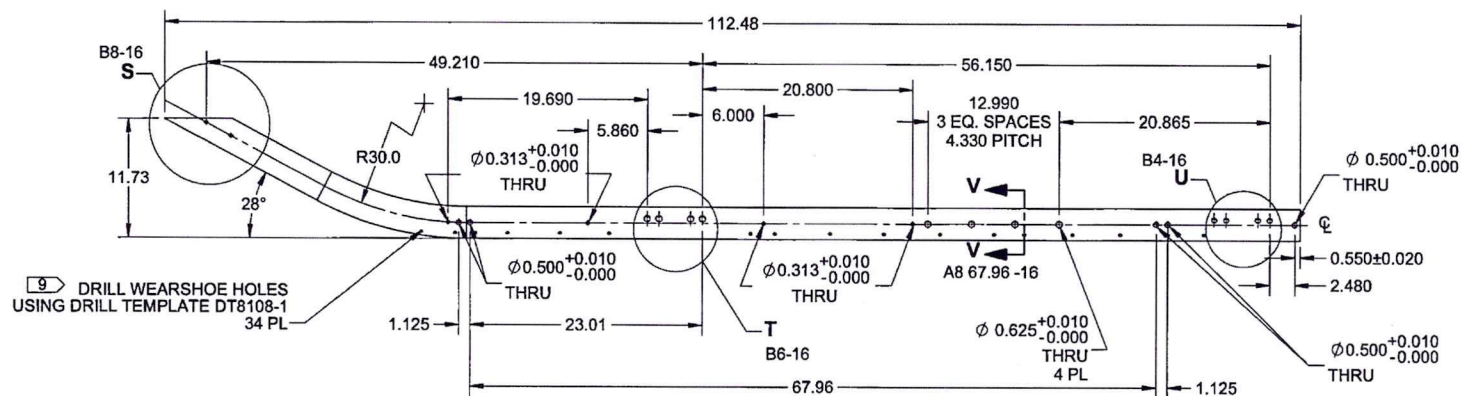


**SECTION R-R**  
SCALE 4X, 4 PL

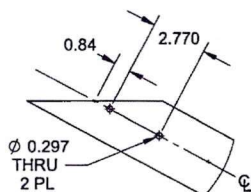
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|          |            |          |                                                                                                                                                                                                                                                                                                              |               |
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| APPROVED | DESIGN     | MM       | <b>DART AEROSPACE USA, INC.</b>                                                                                                                                                                                                                                                                              |               |
|          | DRAWN      | ZF       | EUGENE, OR                                                                                                                                                                                                                                                                                                   |               |
|          | CHECKED    | MW       | DRAWING NO.                                                                                                                                                                                                                                                                                                  | REV. H        |
|          | MFG. APPR. | DD       | <b>D2750</b>                                                                                                                                                                                                                                                                                                 | SHEET 6 OF 16 |
|          | APPROVED   | NO       | TITLE                                                                                                                                                                                                                                                                                                        | SCALE         |
|          | DE APPR.   | DS       | <b>350 SKIDTUBE ASSEMBLY</b>                                                                                                                                                                                                                                                                                 | NTS           |
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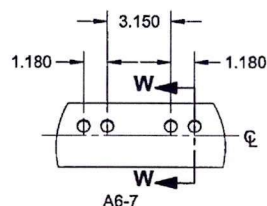




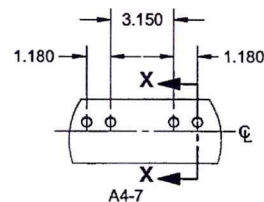
# **D2750-3 LH SKIDTUBE**



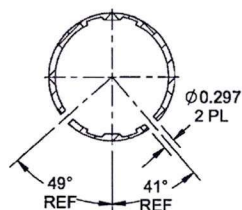
**DETAIL S**  
SCALE 2X



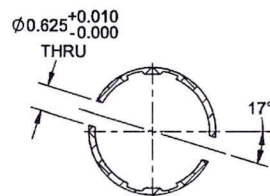
**DETAIL T**  
SCALE 2X



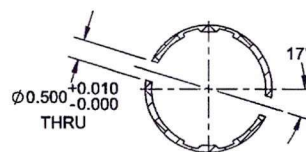
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 4X, 17 PL



**SECTION W-W**  
SCALE 4X, 4 PL



**SECTION X-X**  
SCALE 4X, 4 PL

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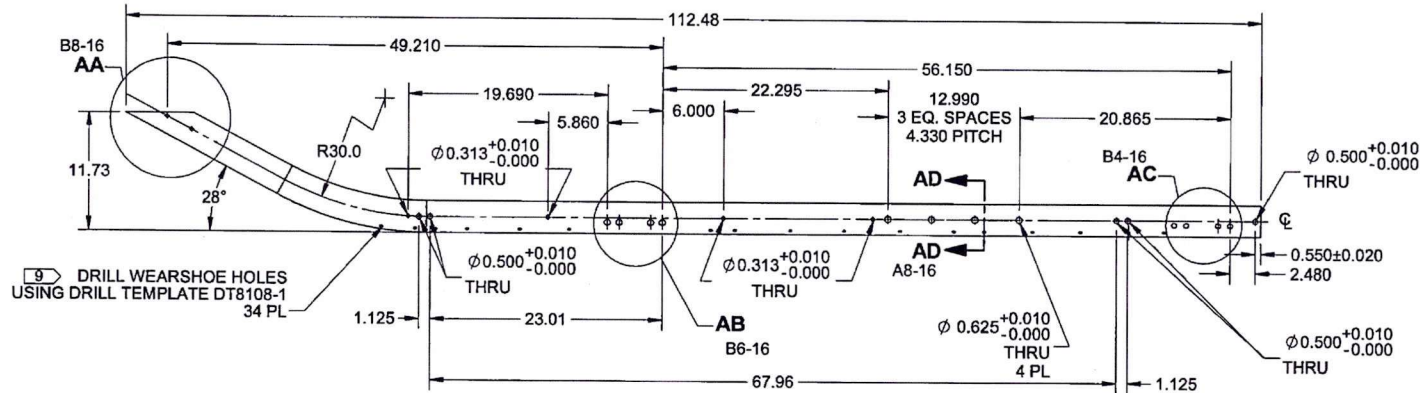
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| DESIGN     | MM       |
| DRAWN      | ZF       |
| CHECKED    | MW       |
| MFG. APPR. | DD       |
| APPROVED   | NO       |
| DE APPR.   | DS       |
| DATE       | 18.03.05 |

|                                               |              |
|-----------------------------------------------|--------------|
| <b>DART AEROSPACE USA, INC.</b><br>EUGENE, OR |              |
| DRAWING NO.<br><b>D2750</b>                   | REV. H       |
| TITLE<br><b>350 SKIDTUBE ASSEMBLY</b>         | SCALE<br>NTS |

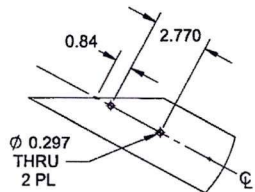
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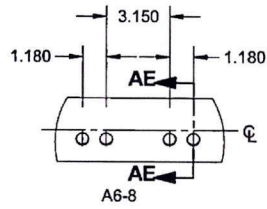
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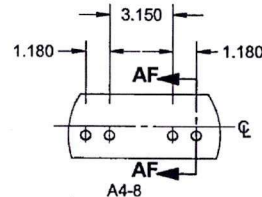
**D2750-4 RH SKIDTUBE**



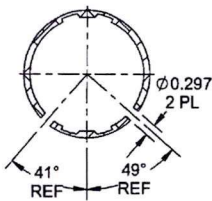
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SCALE 2X



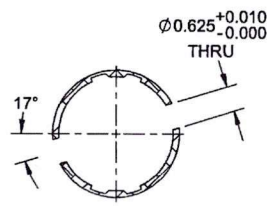
**DETAIL AB**  
SCALE 2X



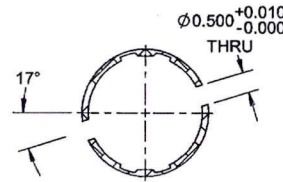
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 4X, 17 PL



**SECTION AE-AE**  
SCALE 4X, 4 PL

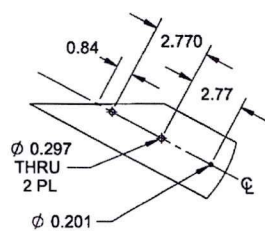
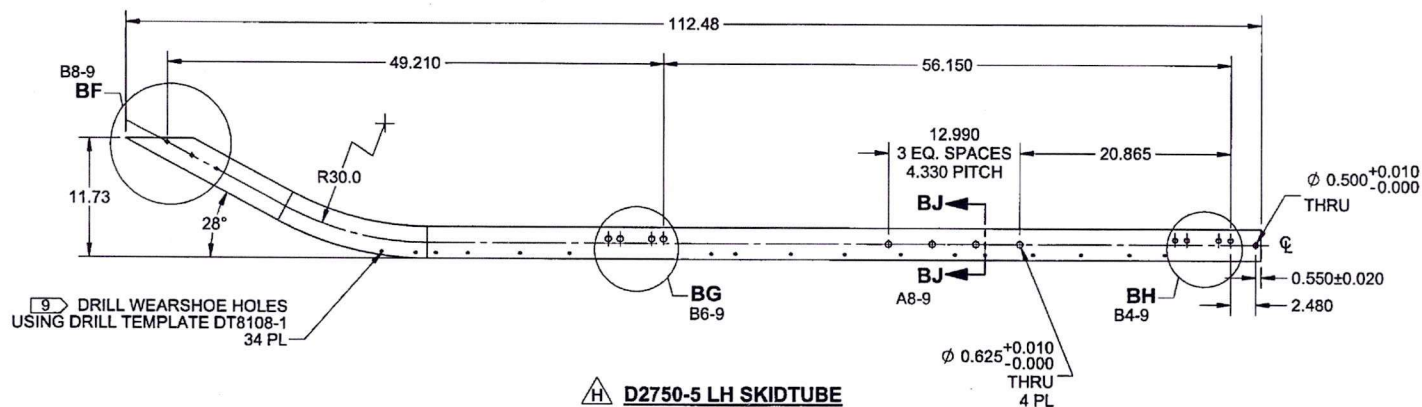


**SECTION AF-AF**  
SCALE 4X, 4 PL

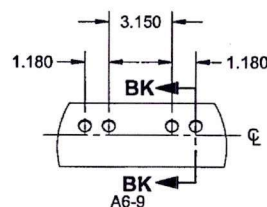
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|          | DRAWN      | ZF       |                                                                                                                                                                                                                                                                                     |               |
|          | CHECKED    | MW       | DRAWING NO.                                                                                                                                                                                                                                                                         | REV. H        |
|          | MFG. APPR. | DD       | D2750                                                                                                                                                                                                                                                                               | SHEET 8 OF 16 |
|          | APPROVED   | NO       | TITLE                                                                                                                                                                                                                                                                               | SCALE         |
|          | DE APPR.   | DS       | 350 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                               | NTS           |
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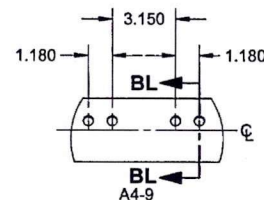




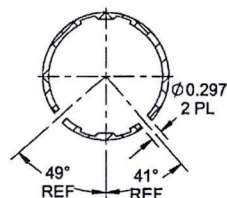
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**DETAIL BF**  
SCALE 2X



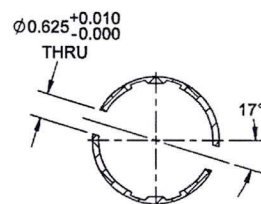
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**DETAIL BK**  
SCALE 2X



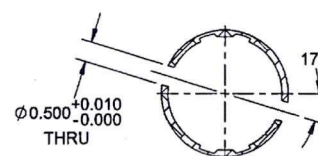
D3-9  
**DETAIL BL**  
SCALE 2X



D4-9  
**SECTION BJ-BJ**  
SCALE 4X, 17 PL



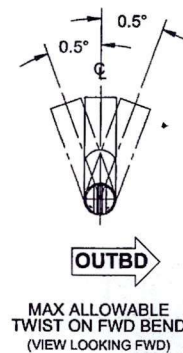
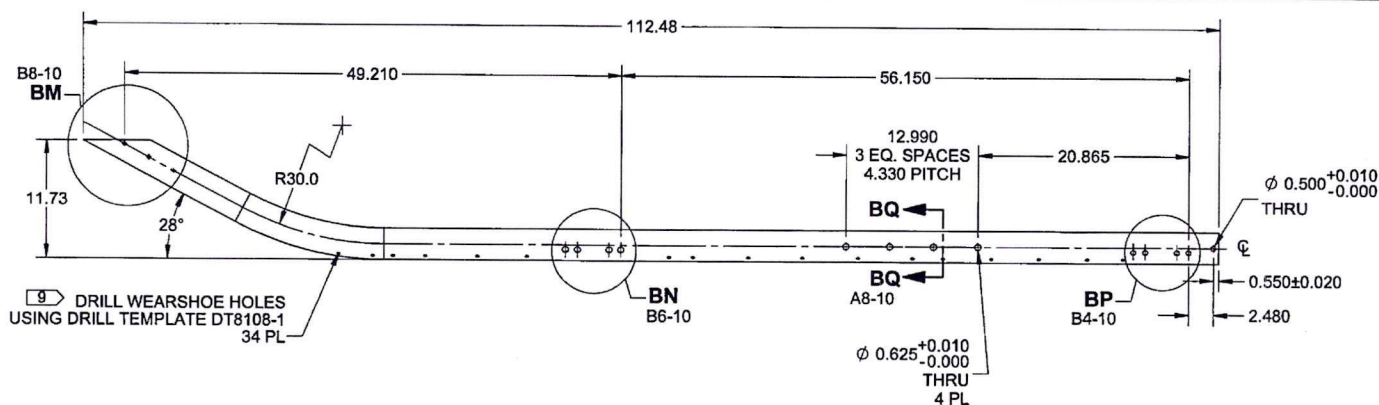
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SCALE 4X, 4 PL



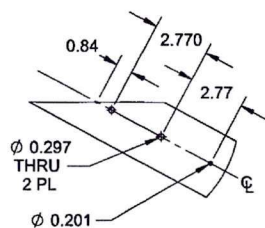
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**SECTION BL-BL**  
SCALE 4X, 4 PL

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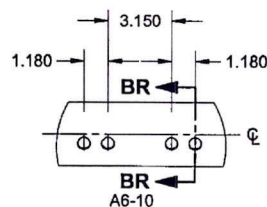
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| APPROVED | DESIGN     | MM       | DART AEROSPACE USA, INC.                                                                                                                                                                                                                                                            |               |
|          | DRAWN      | ZF       | EUGENE, OR                                                                                                                                                                                                                                                                          |               |
|          | CHECKED    | MW       | DRAWING NO.                                                                                                                                                                                                                                                                         | REV. H        |
|          | MFG. APPR. | DD       | D2750                                                                                                                                                                                                                                                                               | SHEET 9 OF 16 |
|          | APPROVED   | NO       | TITLE                                                                                                                                                                                                                                                                               | SCALE         |
|          | DE APPR.   | DS       | 350 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                               | NTS           |
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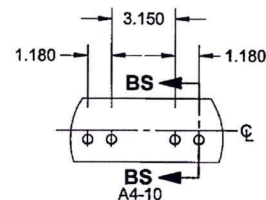
**D2750-6 RH SKIDTUBE**



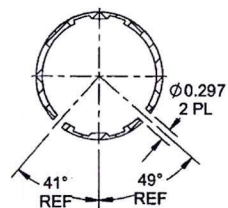
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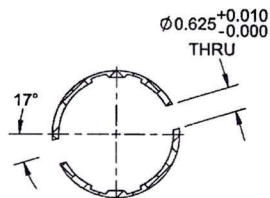
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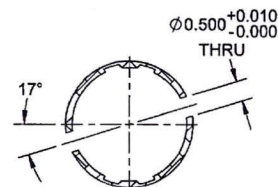
**DETAIL BP**  
SCALE 2X



**SECTION BQ-BQ**  
SCALE 4X, 17 PL



**SECTION BR-BR**  
SCALE 4X, 4 PL



**SECTION BS-BS**  
SCALE 4X, 4 PL

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2019 OCT 19

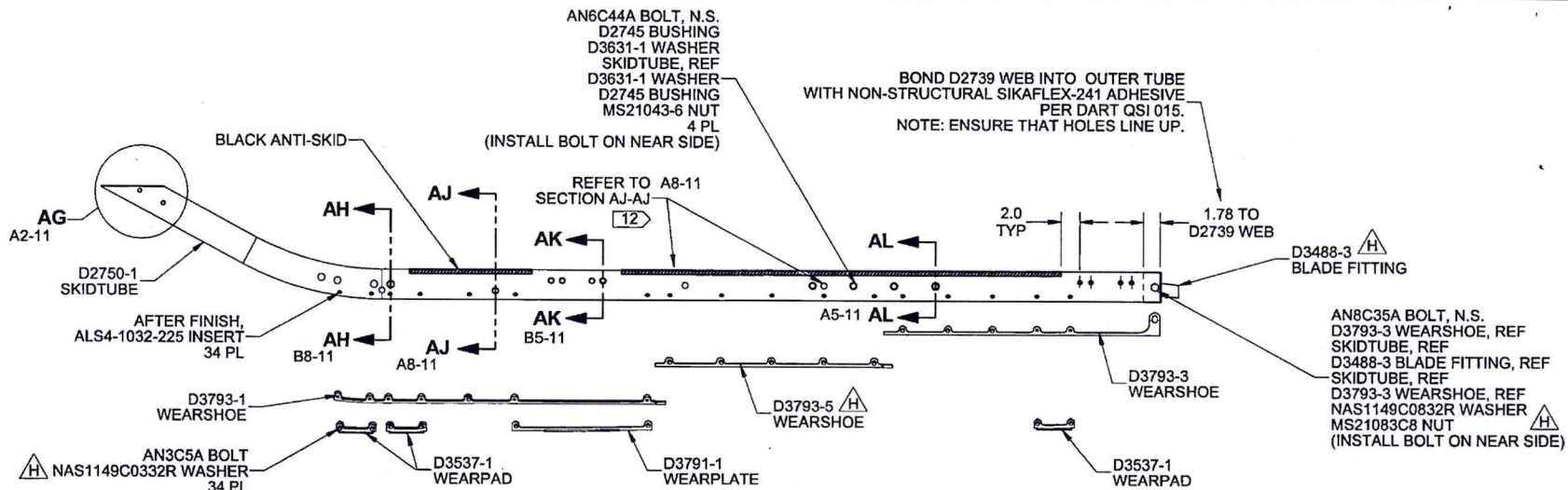
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| DESIGN     | MM       |
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| CHECKED    | MW       |
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| APPROVED   | NO       |
| DE APPR.   | DS       |
| DATE       | 18.03.05 |

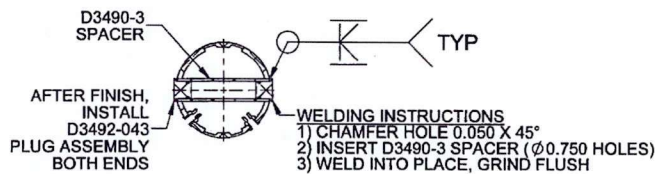
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| <b>DART AEROSPACE USA, INC.</b><br>EUGENE, OR |                |
| DRAWING NO.<br><b>D2750</b>                   | REV. H         |
| TITLE<br><b>350 SKIDTUBE ASSEMBLY</b>         | SHEET 10 OF 15 |
| SCALE                                         | NTS            |

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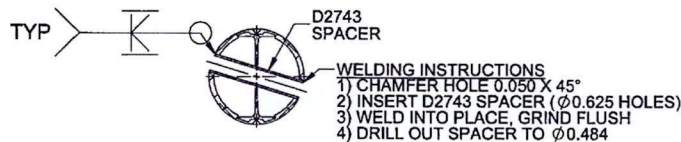




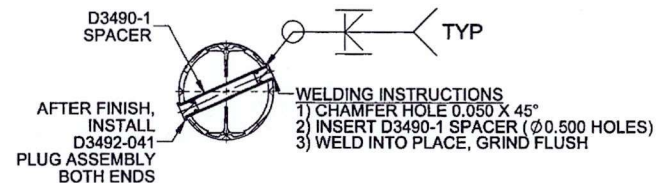
### D2750-041 350 SKIDTUBE ASSEMBLY, LH



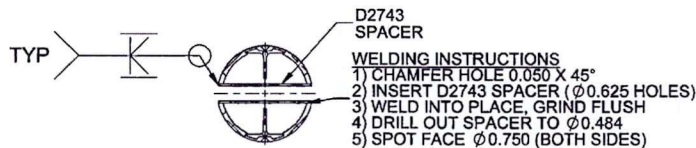
**SECTION AH-AH**  
SCALE 3X, 4 PL



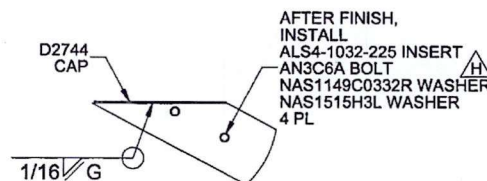
**SECTION AK-AK**  
SCALE 3X, 4 PL



**SECTION AJ-AJ**  
SCALE 3X, 4 PL



**SECTION AL-AL**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**DETAIL AG**  
SCALE 2X

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2018 OCT 19

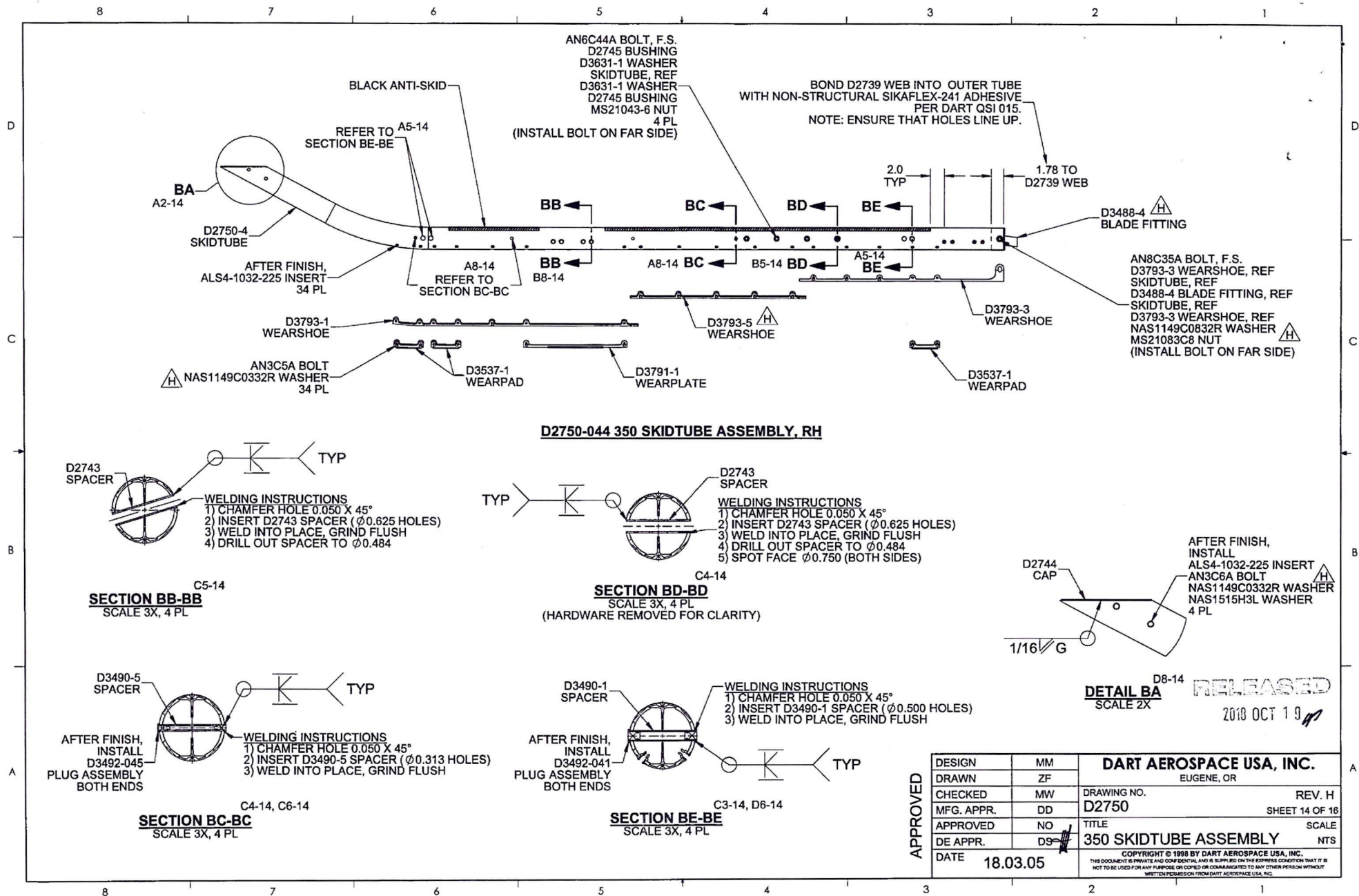
|          |            |          |                                                                                                                                                                                                                                                                                     |                |
|----------|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| APPROVED | DESIGN     | MM       | DART AEROSPACE USA, INC.                                                                                                                                                                                                                                                            |                |
|          | DRAWN      | ZF       | EUGENE, OR                                                                                                                                                                                                                                                                          |                |
|          | CHECKED    | MW       | DRAWING NO.                                                                                                                                                                                                                                                                         | REV. H         |
|          | MFG. APPR. | DD       | D2750                                                                                                                                                                                                                                                                               | SHEET 11 OF 16 |
|          | APPROVED   | NO       | TITLE                                                                                                                                                                                                                                                                               | SCALE          |
|          | DE APPR.   | DS       | 350 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                               | NTS            |
|          | DATE       | 18.03.05 | COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |                |





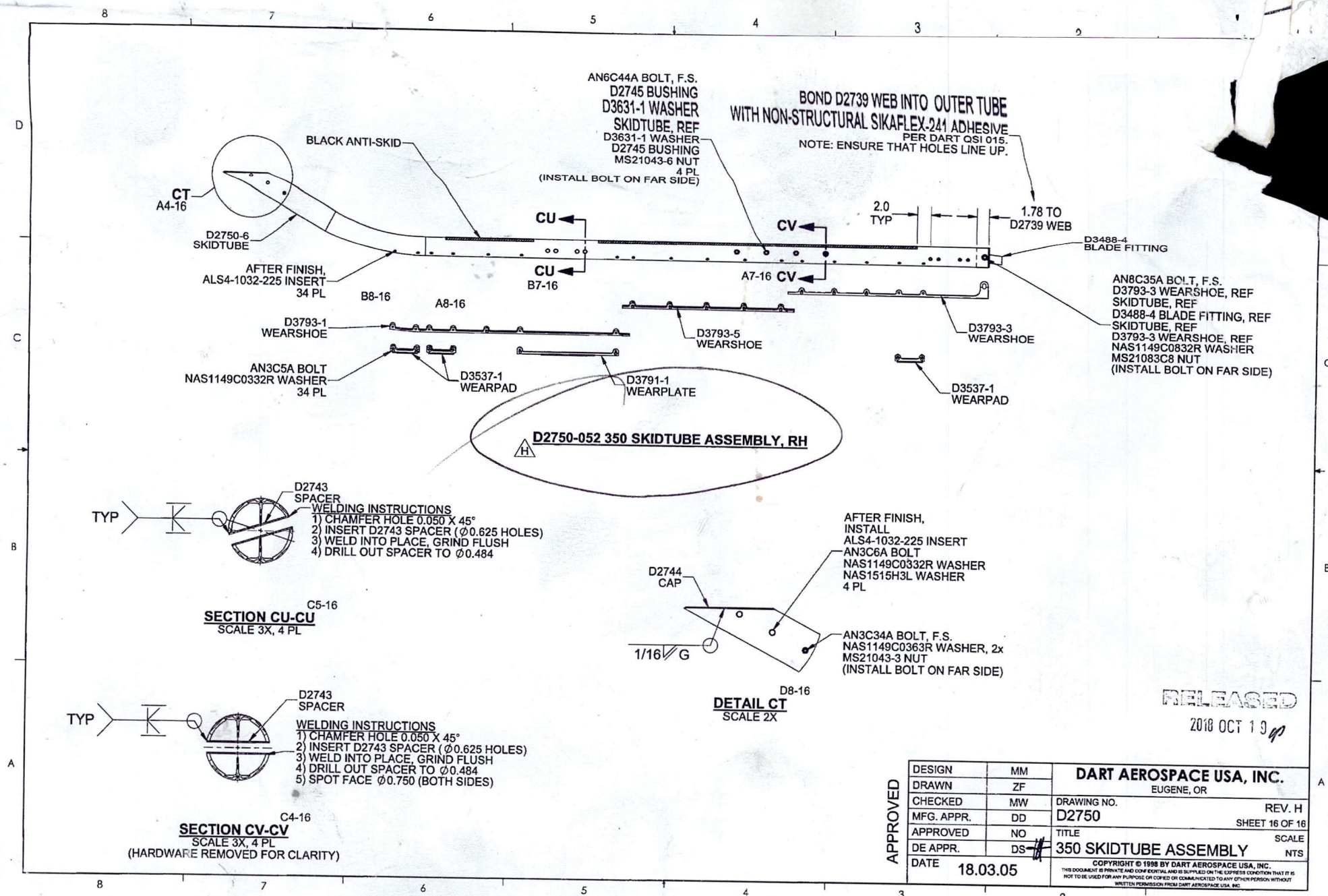












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2018 OCT 19

|               |    |                                                                                                                                                                                                                                                                                                         |                |
|---------------|----|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| DESIGN        | MM | DART AEROSPACE USA, INC.<br>EUGENE, OR                                                                                                                                                                                                                                                                  |                |
| DRAWN         | ZF |                                                                                                                                                                                                                                                                                                         |                |
| CHECKED       | MW | DRAWING NO.                                                                                                                                                                                                                                                                                             | REV. H         |
| MFG. APPR.    | DD | D2750                                                                                                                                                                                                                                                                                                   | SHEET 16 OF 17 |
| APPROVED      | NO | TITLE                                                                                                                                                                                                                                                                                                   | SCALE          |
| DE APPR.      | DS | 350 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                                                                                   | NTS            |
| DATE 18.03.05 |    | COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |                |





## 5.0 PARTS LIST

D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 008 AND SUBSEQUENT  
D350-636-021/-022 SKIDTUBES AT CHG 001 AND SUBSEQUENT

| Item | Qty<br>-011 | Qty<br>-012 | Qty<br>-013 | Qty<br>-014 | Qty<br>-021 | Qty<br>-022 | Qty<br>-049 | Part Number    | Description                                                                |
|------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|----------------|----------------------------------------------------------------------------|
|      | X           |             |             |             |             |             |             | D350-636-011   | SKIDTUBE INSTALLATION, LH,<br>AERAZUR/DART CYLINDRICAL<br>FLOAT COMPATIBLE |
|      |             | X           |             |             |             |             |             | D350-636-012   | SKIDTUBE INSTALLATION, RH,<br>AERAZUR/DART CYLINDRICAL<br>FLOAT COMPATIBLE |
|      |             |             | X           |             |             |             |             | D350-636-013   | SKIDTUBE INSTALLATION, LH<br>AIRCRAISER/DART TRI-BAG<br>FLOAT COMPATIBLE   |
|      |             |             |             | X           |             |             |             | D350-636-014   | SKIDTUBE INSTALLATION, RH<br>AIRCRAISER/DART TRI-BAG<br>FLOAT COMPATIBLE   |
|      |             |             |             |             | X           |             |             | D350-636-021   | SKIDTUBE INSTALLATION, LH, STD                                             |
|      |             |             |             |             |             | X           |             | D350-636-022   | SKIDTUBE INSTALLATION, RH, STD                                             |
|      |             |             |             |             |             |             | X           | D350-636-049   | WEARSHOE KIT                                                               |
| 1    | 1           |             |             |             |             |             |             | D2750-041      | SKIDTUBE ASSEMBLY, LH                                                      |
| 1    |             | 1           |             |             |             |             |             | D2750-042      | SKIDTUBE ASSEMBLY, RH                                                      |
| 1    |             |             | 1           |             |             |             |             | D2750-043      | SKIDTUBE ASSEMBLY, LH                                                      |
| 1    |             |             |             | 1           |             |             |             | D2750-044      | SKIDTUBE ASSEMBLY, RH                                                      |
| 1    |             |             |             |             | 1           |             |             | D2750-051      | SKIDTUBE ASSEMBLY, LH                                                      |
| 1    |             |             |             |             |             | 1           |             | D2750-052      | SKIDTUBE ASSEMBLY, RH                                                      |
| *1   | 1           |             |             |             |             |             |             | D2750-1        | SKIDTUBE WELDMENT, LH                                                      |
| *1   |             | 1           |             |             |             |             |             | D2750-2        | SKIDTUBE WELDMENT, RH                                                      |
| *1   |             |             | 1           |             |             |             |             | D2750-3        | SKIDTUBE WELDMENT, LH                                                      |
| *1   |             |             |             | 1           |             |             |             | D2750-4        | SKIDTUBE WELDMENT, RH                                                      |
| 1    |             |             |             |             | 1           |             |             | D2750-5        | SKIDTUBE WELDMENT, LH                                                      |
| 1    |             |             |             |             |             | 1           |             | D2750-6        | SKIDTUBE WELDMENT, RH                                                      |
| **2  | 8           | 8           | 8           | 8           | 8           | 8           |             | 350A41-1027-20 | SCREW                                                                      |
| **3  | 8           | 8           | 8           | 8           | 8           | 8           |             | 23119AG120LE   | WASHER                                                                     |
| **4  | 8           | 8           | 8           | 8           | 8           | 8           |             | 22541N120      | NUT                                                                        |
| *5   | 1           | 1           | 1           | 1           | 1           | 1           |             | AN8C35A        | BOLT                                                                       |
| *6A  | 1           | 1           | 1           | 1           | 1           | 1           |             | NAS1149C0832R  | WASHER                                                                     |
| *7   | 1           | 1           | 1           | 1           | 1           | 1           |             | MS21083C8      | NUT                                                                        |
| 8    | 1           |             | 1           |             | 1           |             |             | D3488-3        | BLADE FITTING, LH                                                          |
| 8    |             | 1           |             | 1           |             | 1           |             | D3488-4        | BLADE FITTING, RH                                                          |
| 9    | 1           | 1           | 1           | 1           | 1           | 1           |             | D2741          | BLADE                                                                      |
| 10   | 2           | 2           | 2           | 2           | 2           | 2           |             | AN8C21A        | BOLT                                                                       |
| 11   | 2           | 2           | 2           | 2           | 2           | 2           |             | NAS1149DO863J  | WASHER                                                                     |
| 11C  |             |             |             |             |             |             | 8           | D3672-1        | WASHER                                                                     |
| 12   | 2           | 2           | 2           | 2           | 2           | 2           |             | MS21083C8      | NUT                                                                        |
| *14  | 4           | 4           | 4           | 4           | 4           | 4           |             | AN6C44A        | BOLT                                                                       |
| *15  | 8           | 8           | 8           | 8           | 8           | 8           |             | D2745          | BUSHING                                                                    |
| *16  | 4           | 4           | 4           | 4           | 4           | 4           |             | MS21043-6      | NUT                                                                        |
| *17  | 8           | 8           | 8           | 8           | 8           | 8           |             | D3631-1        | WASHER                                                                     |
| *18  | 4           | 4           | 4           | 4           | 4           | 4           |             | ALS4-1032-225  | INSERT                                                                     |
| *19  | 4           | 4           | 4           | 4           | 4           | 4           |             | AN3C6A         | BOLT                                                                       |
| *20A | 4           | 4           | 4           | 4           | 4           | 4           |             | NAS1149C0332R  | WASHER                                                                     |
| *20B | 4           | 4           | 4           | 4           | 4           | 4           |             | NAS1515H3L     | WASHER                                                                     |
| *22  | 3           | 3           | 3           | 3           | 3           | 3           | 3           | D3537-1        | WEARPAD                                                                    |

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Revision: K

Date: 18.04.04

## Change Record

PAGE 1 OF 1

Part Number: D350-636-021/-022Description: SKIDTUBE INSTALLATION LH/RH, STD[illegible]